

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re Application of:	§	
	§	
John D. Hottovy, <i>et al.</i>	§	Group Art Unit: 1713
	§	
Serial No.: 09/213,147	§	Examiner: W. Cheung
	§	
Filed: December 18 th , 1998	§	Atty. Docket: 33603US1
	§	
For: A PROCESS FOR	§	
PRODUCING	§	
POLYOLEFINS	§	

PRELIMINARY AMENDMENT UNDER 37 C.F.R. 1.115

The applicants respectfully request that the Examiner enter this Preliminary Amendment into the record.

Please amend the application as follows.

IN THE SPECIFICATION

On each page, in the upper right hand corner, please delete 33603US and substitute therefor 33603US1.

On page 1, line 1, please insert "This application is a Continuation In Part (CIP) of application 09/213,147.

Please delete the second and third paragraphs of page 5 and substitute the following paragraphs therefore.

Step 1 is mixing Stream 1 with Stream 2 to produce Stream 3 wherein said mixing occurs in Mixing Zone One. Mixing Zone One (100) can be any reactor that can perform a slurry polymerization. However, it is preferred that Mixing Zone One (100) is selected from the group consisting of a loop reactor and a

stirred tank. Preferably, Mixing Zone One (100) comprises a loop reactor, as described in U.S. Patents 4,121,029 and 4,424,341, which is hereby incorporated by reference. Generally, in said loop reactor, at least one catalyst, at least one diluent, and at least one monomer are added continuously to and are moved continuously through said loop reactor. The monomers polymerize and form particulates, and said particulates are suspended in said polymerization reaction mixture.

The temperature in Mixing Zone One (100) is such that substantially all of the polyolefin produced is insoluble in said diluent. The polymerization temperature depends on the diluent chosen and generally is in the range of about 30°C to about 120°C. The temperature should be below about 120°C to prevent the polyolefin from dissolving or melting in said diluent. In ethylene polymer production, the temperature should be in the range of about 65°C to about 110°C, in order to more efficiently produce ethylene polymer.

The pressure employed in said Mixing Zone One (100) is that which is sufficient to maintain the diluent substantially in the liquid phase. Normally, said pressure ranges from about 100 psia to about 2000 psia. In ethylene polymer production, said pressure in Mixing Zone One (100) ranges from about 500 psia to about 700 psia, in order to optimally produce ethylene polymer.

On page 6, please delete the second paragraph and insert the following therefore.

The amount of deactivating agent employed depends on the type of catalyst used. Optimally, the amount of deactivating agent is that which will substantially stop the polymerization reaction but not so much as to require the use of a scavenger, such as for example, diethyl zinc, to be utilized to remove catalyst poisons. Generally, the amount of deactivating agent utilized ranges from about 10^{-12} moles of deactivating agent per mole of catalyst to about 10^3 moles of deactivating agent per mole of catalyst. Preferably, the amount of deactivating agent utilized ranges from about 10^{-6} moles of deactivating agent per mole of catalyst to about 10^2 moles of deactivating agent per mole of catalyst. More preferably, the amount of deactivating agent utilized ranges from about 10^{-3} moles of deactivating agent per mole of catalyst to about 10 moles of deactivating agent per mole of catalyst. Most preferably, 0.10 moles of deactivating agent per mole of catalyst to 5 moles of deactivating agent per mole of catalyst are utilized.

On page 7, please delete the first paragraph and substitute the following two paragraphs therefore.

By utilizing said deactivating agent in this invention, polymerization can be slowed, or substantially stopped, when downstream equipment is being repaired or process control problems are being corrected. Then, polymerization can be restarted. The term "restarted" means to re-establish the polymerization reaction after the deactivated agent substantially deactivates the catalyst. Preferably, when polymerization is slowed or stopped by said deactivating agent, a portion of the polyolefin is circulated out of the slurry polymerization reactor prior to restarting

polymerization. While the polyolefin is being circulated out of the slurry polymerization reactor, the pressure in the reactor is maintained by the addition of diluent or monomer or both. To restart the polymerization, catalyst is added to the slurry polymerization reactor. Preferably, polymerization is restarted in about 2 to about 6 hours, most preferably, in 3 to 4 hours. This invention allows for minimal time to restart polymerization since polymerization can be restarted without the use of scavengers to remove poisons from the slurry polymerization reactor.

The use of said deactivating agent provides a method to shut down polyolefin production thus minimizing the amount of polyolefins produced that do not meet quality specifications. This process is superior to other methods of slowing or substantially stopping polyolefin production, such as, decreasing or stopping catalyst feed to the slurry polymerization reactor. Decreasing catalyst feed causes production of larger amounts of polyolefins that do not meet quality specifications. Using this invention, the polymerization reaction in a slurry polymerization reactor can be slowed or substantially stopped by using said deactivating agent, and the melt index of the polyolefins produced can still meet product specifications.

By utilizing this invention, silos and their associated equipment can be eliminated from the polyolefin process. Therefore, Separating Zone One (300) comprising at least one flash chamber and said Agglomerating Zone One (600) comprising at least one extruder can be directly connected or “closed-coupled”,

rather than said polyolefin being transported to silos prior to agglomerating. For example, when utilizing the inventive, closed-coupled slurry polymerization process, if an extruder is not functional, the slurry polymerization reactor also must be shut down since no storage silos are available. However, when this invention is utilized, polyolefin production is minimized and the polyolefin quality is optimized. By eliminating these storage silos and related equipment, an estimated cost savings of about 20,000,000 dollars to about 100,000,000 dollars can be obtained based on construction of a 2,000,000,000 pound/yr polyolefin polymerization plant.

IN THE CLAIMS

Please delete claim 1 and substitute amended claim 1.

1.(amended) A process comprising:

(1) mixing Stream 1 with Stream 2 to produce Stream 3;

wherein said mixing occurs in Mixing Zone One;

wherein said Mixing Zone One comprises a slurry polymerization reactor selected from the group consisting of a loop reactor and a stirred tank;

wherein Stream 1 comprises at least one catalyst deactivating agent;

wherein Stream 2 comprises a reaction mixture;

wherein said reaction mixture comprises at least one

polyolefin, at least one catalyst, at least one diluent, and at

least one monomer;

wherein Stream 3 comprises at least one polyolefin, at least one deactivated catalyst, at least one diluent, and at least one monomer;

- (2) transporting at least a portion of Stream 3 from said Mixing Zone One through Stream Zone 1 and to Separating Zone One; wherein said Separating Zone One comprises at least one flash chamber;
- (3) separating Stream 3 in said Separating Zone One into Stream 4 and Stream 5; wherein said Stream 4 comprises a polyolefin lean stream wherein the majority of said Stream 4 comprises at least one diluent; wherein said Stream 5 comprises a polyolefin rich stream wherein the majority of said Stream 5 comprises at least one polyolefin;
- (4) transporting Stream 5 from said Separating Zone One through a Stream Zone 3 to an Agglomerating Zone One;
- (5) agglomerating Stream 5 in said Agglomerating Zone One to produce a Stream 6, wherein Stream 6 comprises at least one agglomerated polyolefin;
- (6) transporting Stream 6 from said Agglomerating Zone One through Stream Zone 4 to a Product Recovery Zone.

Please delete claim 10 and substitute amended claim 10.

10.(amended)A process according to Claim 1 wherein said Separating Zone

One comprises:

- (3.1) heating Stream 3 in Heating Zone One producing Stream 3A;
wherein said Heating Zone One comprises a flash line heater;
- (3.2) transporting Stream 3A from said Heating Zone One through
Stream Zone 1A to a High Pressure Separating Zone;
wherein said High Pressure Separating Zone comprises at
least one flash chamber;
- (3.3) separating Stream 3A in said High Pressure Separating Zone
to produce Stream 4A and Stream 5A;
wherein said Stream 4A comprises a polyolefin lean stream;
wherein the majority of said Stream 4A comprises at least one
diluent;
wherein said Stream 5A comprises a polyolefin rich stream;
wherein the majority of said Stream 5A comprises at least one
polyolefin;
- (3.9) transporting Stream 5A from said High Pressure Separating
Zone through Stream Zone 1B to a Purge Zone Two;
- (3.10) purging Stream 5A in said Purge Zone Two with a gas to
separate Stream 5A into Stream 4C and Stream 5D;

wherein said Purge Zone Two comprises at least one purge column;

wherein said Stream 4C comprises a polyolefin lean stream;

wherein the majority of said Stream 4C comprises said gas and at least one diluent;

wherein said Stream 5D comprises a polyolefin rich stream;

wherein the majority of said Stream 5D comprise at least one polyolefin;

(3.11) transporting Stream 5D from said Purge Zone Two through a Stream Zone 3B to an Agglomerating Zone One.

11.(amended)A process according to Claim 1 wherein said Separating Zone

One comprises:

(3.1) heating Stream 3 in Heating Zone One producing Stream 3A;
wherein said Heating Zone One comprises at least one flash line heater;

(3.2) transporting Stream 3A from said Heating Zone One through Stream Zone 1A to a High Pressure Separating Zone;

(3.3) separating Stream 3A in said High Pressure Separating Zone to produce Stream 4A and Stream 5A;

wherein said High Pressure Separating Zone comprises at least one flash chamber;

wherein said Stream 4A comprises a polyolefin lean stream;
wherein the majority of said Stream 4A comprises at least one
diluent;

wherein said Stream 5A comprises a polyolefin rich stream;
wherein the majority of said Stream 5A comprises at least one
polyolefin;

(3.4) transporting Stream 5A from said High Pressure Separating
Zone through Stream Zone 1B to a Low Pressure Separating
Zone;

(3.5) further separating Stream 5A in said Low Pressure Separating
Zone to produce Stream 4B and Stream 5B;

wherein said Low Pressure Separating Zone comprises at
least one flash chamber;

wherein said Stream 4B comprises a polyolefin lean stream;
wherein the majority of said Stream 4B comprises at
least one diluent;

wherein said Stream 5B comprises a polyolefin rich
stream;

wherein the majority of said Stream 5B comprises at
least one polyolefin;

(3.6) transporting Stream 5B from said Low Pressure Separating
Zone through Stream Zone 1C to a Purge Zone One;

- (3.7) purging Stream 5B in said Purge Zone One with a gas to separate Stream 5B into Stream 4D and Stream 5C; wherein said Purge Zone One comprises at least one purge column; wherein said Stream 4D comprises a polyolefin lean stream; wherein the majority of said Stream 4D comprises said gas and at least one diluent; wherein said Stream 5C comprises a polyolefin rich stream; wherein the majority of said Stream 5C comprises at least one polyolefin;
- (3.8) transporting Stream 5B from said Purge Zone One through a Stream Zone 3A to an Agglomerating Zone One. wherein Stream 8 comprises a polyolefin rich stream wherein a majority of said Stream 8 comprises at least one polyolefin not suitable for agglomerating; and wherein Stream 9 comprises a polyolefin rich stream wherein a majority of said Stream 9 comprises at least one polyolefin suitable for agglomerating;
- (3.14) transporting Stream 9 from said Alternate Separating Zone through Stream Zone 8 to said Agglomerating Zone One.

Please add the following new claims.

15. A process comprising:

introducing a catalyst deactivating agent into an olefin

polymerization zone;

wherein said olefin polymerization zone comprises a slurry

polymerization reactor selected from the group consisting of a loop

reactor and a stirred tank;

thereafter passing polymerization zone effluent comprising

deactivated catalyst, diluent and monomer to a separation zone;

wherein said separation zone comprises at least one flash chamber;

separating said polymerization zone effluent in said separation zone

into a polyolefin lean stream comprising diluent and a polyolefin

rich stream; and

passing said polyolefin rich stream to an extrusion zone.

16. A process according to claim 15 wherein said polyolefin rich stream

is passed directly from said separation zone to said extrusion zone.

17. A process according to claim 15 wherein said separation zone

comprises a high pressure separating zone and wherein said polyolefin rich stream

is passed directly from said high pressure separating zone to a purge zone and then

directly to said extrusion zone.

CONCLUDING REMARKS

Based on these comments, the Examiner is respectfully requested to enter this Preliminary Amendment into the record. Any questions can be directed to Applicants' attorney at the number below.

Respectfully submitted,

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CERTIFICATE OF EXPRESS MAILING

I hereby certify that this correspondence is being deposited with the United States Postal Service as Express Mail No. EL732378835US in an envelope addressed to: Assistant Commissioner for Patents, Box Patent Application, Washington, D.C. 20231, on

August 7th, 2001
(Date)
Polly C. Owen
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APPENDIX
IN THE SPECIFICATION

On each page, in the upper right hand corner, please delete 33603US and substitute therefor 33603US1.

On page 1, line 1, please insert This application is a Continuation In Part (CIP) of application 09/213,147.

On page 5, lines 4-14, please amend the specification as follows:

[Step 1 is mixing Stream 1 with Stream 2 to produce Stream 3.

Generally, Stream 1 comprises at least one catalyst deactivating agent.

Said deactivating agent can be any chemical compound capable of deactivating catalysts. Deactivating agents can be selected from the group consisting of water, alcohols, and other oxygen-containing materials. Suitable alcohols include, but are not limited to, methanol, ethanol, and propanol. Said oxygen-containing materials are selected from the group consisting of esters, ketones, aldehydes, and organic acids. Suitable examples of said oxygen-containing materials include, but are not limited to, ethyl acetate and acetic acid. Preferably, said deactivating agent is water due to availability and ease of use.]

Step 1 is mixing Stream 1 with Stream 2 to produce Stream 3 wherein said mixing occurs in Mixing Zone One. Mixing Zone One (100) can be any reactor that can perform a slurry polymerization. However, it is preferred that Mixing Zone One (100) is selected from the group consisting of a loop reactor and a stirred tank. Preferably, Mixing Zone One (100) comprises a loop reactor, as

described in U.S. Patents 4,121,029 and 4,424,341, which is hereby incorporated by reference. Generally, in said loop reactor, at least one catalyst, at least one diluent, and at least one monomer are added continuously to and are moved continuously through said loop reactor. The monomers polymerize and form particulates, and said particulates are suspended in said polymerization reaction mixture.

The temperature in Mixing Zone One (100) is such that substantially all of the polyolefin produced is insoluble in said diluent. The polymerization temperature depends on the diluent chosen and generally is in the range of about 30°C to about 120°C. The temperature should be below about 120°C to prevent the polyolefin from dissolving or melting in said diluent. In ethylene polymer production, the temperature should be in the range of about 65°C to about 110°C, in order to more efficiently produce ethylene polymer.

The pressure employed in said Mixing Zone One (100) is that which is sufficient to maintain the diluent substantially in the liquid phase. Normally, said pressure ranges from about 100 psia to about 2000 psia. In ethylene polymer production, said pressure in Mixing Zone One (100) ranges from about 500 psia to about 700 psia, in order to optimally produce ethylene polymer.

On page 6, lines 9-19, please amend the specification as follows:

[The amount of deactivating agent employed depends on the type of catalyst system used. In general, the amount of deactivating agent utilized ranges from about 10^{-12} moles of deactivating agent per mole of catalyst to about 10^3

moles of deactivating agent per mole of catalyst. Preferably, about 10^{-6} moles of deactivating agent per mole of catalyst to about 10^2 moles of deactivating agent per mole of catalyst are utilized. More preferably, the amount of deactivating agent utilized ranges from about 10^{-3} moles of deactivating agent per mole of catalyst to about 10 moles of deactivating agent per mole of catalyst. Most preferably, about 0.10 moles of deactivating agent per mole of catalyst to about 5 moles of deactivating agent per mole of catalyst are utilized.]

The amount of deactivating agent employed depends on the type of catalyst used. Optimally, the amount of deactivating agent is that which will substantially stop the polymerization reaction but not so much as to require the use of a scavenger, such as for example, diethyl zinc, to be utilized to remove catalyst poisons. Generally, the amount of deactivating agent utilized ranges from about 10^{-12} moles of deactivating agent per mole of catalyst to about 10^3 moles of deactivating agent per mole of catalyst. Preferably, the amount of deactivating agent utilized ranges from about 10^{-6} moles of deactivating agent per mole of catalyst to about 10^2 moles of deactivating agent per mole of catalyst. More preferably, the amount of deactivating agent utilized ranges from about 10^{-3} moles of deactivating agent per mole of catalyst to about 10 moles of deactivating agent per mole of catalyst. Most preferably, 0.10 moles of deactivating agent per mole of catalyst to 5 moles of deactivating agent per mole of catalyst are utilized.

On page 7, lines 1-14, please amend the specification as follows:

[By utilizing said deactivating agent in this invention, polymerization can be slowed, or stopped, when downstream equipment is being repaired or process control problems are being corrected. In addition, the use of said deactivating agent can provide a method to shutdown polyolefin production which can minimize the production of polyolefins that do not meet quality specifications as compared to other methods of stopping polyolefin production, such as, stopping catalyst feed to said Mixing Zone One (100). Therefore, by utilizing this invention, silos and their associated equipment can be eliminated from the polyolefin process. Said Separating Zone One (300) and said Agglomerating Zone One (600) can be directly connected or “closed coupled”, rather than said polyolefin being transported to silos prior to agglomerating. By eliminating this equipment, an estimated cost savings of about 20,000,000 dollars to about 100,000,000 dollars can be obtained based on construction of a 2,000,000,000 pound/yr polyolefin polymerization plant.]

By utilizing said deactivating agent in this invention, polymerization can be slowed, or substantially stopped, when downstream equipment is being repaired or process control problems are being corrected. Then, polymerization can be restarted. The term “restarted” means to re-establish the polymerization reaction after the deactivated agent substantially deactivates the catalyst. Preferably, when polymerization is slowed or stopped by said deactivating agent, a portion of the polyolefin is circulated out of the slurry polymerization reactor prior to restarting

polymerization. While the polyolefin is being circulated out of the slurry polymerization reactor, the pressure in the reactor is maintained by the addition of diluent or monomer or both. To restart the polymerization, catalyst is added to the slurry polymerization reactor. Preferably, polymerization is restarted in about 2 to about 6 hours, most preferably, in 3 to 4 hours. This invention allows for minimal time to restart polymerization since polymerization can be restarted without the use of scavengers to remove poisons from the slurry polymerization reactor.

The use of said deactivating agent provides a method to shut down polyolefin production thus minimizing the amount of polyolefins produced that do not meet quality specifications. This process is superior to other methods of slowing or substantially stopping polyolefin production, such as, decreasing or stopping catalyst feed to the slurry polymerization reactor. Decreasing catalyst feed causes production of larger amounts of polyolefins that do not meet quality specifications. Using this invention, the polymerization reaction in a slurry polymerization reactor can be slowed or substantially stopped by using said deactivating agent, and the melt index of the polyolefins produced can still meet product specifications.

By utilizing this invention, silos and their associated equipment can be eliminated from the polyolefin process. Therefore, Separating Zone One (300) comprising at least one flash chamber and said Agglomerating Zone One (600) comprising at least one extruder can be directly connected or "closed-coupled", rather than said polyolefin being transported to silos prior to agglomerating. For

example, when utilizing the inventive, closed-coupled slurry polymerization process, if an extruder is not functional, the slurry polymerization reactor also must be shut down since no storage silos are available. However, when this invention is utilized, polyolefin production is minimized and the polyolefin quality is optimized. By eliminating these storage silos and related equipment, an estimated cost savings of about 20,000,000 dollars to about 100,000,000 dollars can be obtained based on construction of a 2,000,000,000 pound/yr polyolefin polymerization plant.

IN THE CLAIMS

Please amend the claims as follows:

Please delete claim 1 and substitute amended claim 1.

1.(amended) A process comprising:

(1) mixing Stream 1 with Stream 2 to produce Stream 3;

wherein said mixing occurs in Mixing Zone One;

wherein said Mixing Zone One comprises a slurry polymerization reactor selected from the group consisting of a loop reactor and a stirred tank;

wherein Stream 1 comprises at least one catalyst deactivating agent;

wherein Stream 2 comprises a reaction mixture;

wherein said reaction mixture comprises at least one polyolefin, at least one catalyst, at least one diluent, and at least one monomer;

wherein Stream 3 comprises at least one polyolefin, at least one deactivated catalyst, at least one diluent, and at least one monomer;

- (2) transporting at least a portion of Stream 3 from said Mixing Zone One through Stream Zone 1 and to Separating Zone One;

wherein said Separating Zone One comprises at least one flash chamber;

- (3) separating Stream 3 in said Separating Zone One into Stream 4 and Stream 5;

wherein said Stream 4 comprises a polyolefin lean stream wherein the majority of said Stream 4 comprises at least one diluent;

wherein said Stream 5 comprises a polyolefin rich stream wherein the majority of said Stream 5 comprises at least one polyolefin;

- (4) transporting Stream 5 from said Separating Zone One through a Stream Zone 3 to an Agglomerating Zone One;
- (5) agglomerating Stream 5 in said Agglomerating Zone One to produce a Stream 6, wherein Stream 6 comprises at least one agglomerated polyolefin;
- (6) transporting Stream 6 from said Agglomerating Zone One through Stream Zone 4 to a Product Recovery Zone.

Please delete claim 10 and substitute amended claim 10.

10.(amended)A process according to Claim 1 wherein said Separating Zone

One comprises:

- (3.1) heating Stream 3 in Heating Zone One producing Stream 3A;
wherein said Heating Zone One comprises a flash line heater;
- (3.2) transporting Stream 3A from said Heating Zone One through
Stream Zone 1A to a High Pressure Separating Zone;
wherein said High Pressure Separating Zone comprises at
least one flash chamber;
- (3.3) separating Stream 3A in said High Pressure Separating Zone
to produce Stream 4A and Stream 5A;
wherein said Stream 4A comprises a polyolefin lean stream;
wherein the majority of said Stream 4A comprises at least one
diluent;
wherein said Stream 5A comprises a polyolefin rich stream;
wherein the majority of said Stream 5A comprises at least one
polyolefin;
- (3.9) transporting Stream 5A from said High Pressure Separating
Zone through Stream Zone 1B to a Purge Zone Two;
- (3.10) purging Stream 5A in said Purge Zone Two with a gas to
separate Stream 5A into Stream 4C and Stream 5D;

wherein said Purge Zone Two comprises at least one purge column;

wherein said Stream 4C comprises a polyolefin lean stream;

wherein the majority of said Stream 4C comprises said gas and at least one diluent;

wherein said Stream 5D comprises a polyolefin rich stream;

wherein the majority of said Stream 5D comprise at least one polyolefin;

(3.11) transporting Stream 5D from said Purge Zone Two through a Stream Zone 3B to an Agglomerating Zone One.

11.(amended)A process according to Claim 1 wherein said Separating Zone One comprises:

(3.1) heating Stream 3 in Heating Zone One producing Stream 3A;
wherein said Heating Zone One comprises at least one flash line heater;

(3.2) transporting Stream 3A from said Heating Zone One through Stream Zone 1A to a High Pressure Separating Zone;

(3.3) separating Stream 3A in said High Pressure Separating Zone to produce Stream 4A and Stream 5A;

wherein said High Pressure Separating Zone comprises at least one flash chamber;

wherein said Stream 4A comprises a polyolefin lean stream;
wherein the majority of said Stream 4A comprises at least one
diluent;
wherein said Stream 5A comprises a polyolefin rich stream;
wherein the majority of said Stream 5A comprises at least one
polyolefin;

(3.4) transporting Stream 5A from said High Pressure Separating
Zone through Stream Zone 1B to a Low Pressure Separating
Zone;

(3.5) further separating Stream 5A in said Low Pressure Separating
Zone to produce Stream 4B and Stream 5B;

wherein said Low Pressure Separating Zone comprises at
least one flash chamber;

wherein said Stream 4B comprises a polyolefin lean stream;

wherein the majority of said Stream 4B comprises at
least one diluent;

wherein said Stream 5B comprises a polyolefin rich
stream;

wherein the majority of said Stream 5B comprises at
least one polyolefin;

(3.6) transporting Stream 5B from said Low Pressure Separating
Zone through Stream Zone 1C to a Purge Zone One;

- (3.7) purging Stream 5B in said Purge Zone One with a gas to separate Stream 5B into Stream 4D and Stream 5C;
wherein said Purge Zone One comprises at least one purge column;
wherein said Stream 4D comprises a polyolefin lean stream;
wherein the majority of said Stream 4D comprises said gas and at least one diluent;
wherein said Stream 5C comprises a polyolefin rich stream;
wherein the majority of said Stream 5C comprises at least one polyolefin;
- (3.8) transporting Stream 5B from said Purge Zone One through a Stream Zone 3A to an Agglomerating Zone One.
wherein Stream 8 comprises a polyolefin rich stream wherein a majority of said Stream 8 comprises at least one polyolefin not suitable for agglomerating; and
wherein Stream 9 comprises a polyolefin rich stream wherein a majority of said Stream 9 comprises at least one polyolefin suitable for agglomerating;
- (3.14) transporting Stream 9 from said Alternate Separating Zone through Stream Zone 8 to said Agglomerating Zone One.